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D130-1048-011
Job Sheet 196754



Part No: D130-1048-011

Job Qty: 1 pcs

Part Name: H130/EC130 - Skidtube - Standard w/ Basic Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D130-1048-011 REV.C/ IIN-D130-1048 REV.C IPP REV:A DP verify DD 17.07.09

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Handfinish - 4 - Assembly	1 pcs	7/12/19		0.00	0.50	Handfinish - 4 - 1	11 19-9-11
 Container No: S212708 Part: D130-1048-011 Job No: 196754 Serial No/Batch: S212708 Revision: C/C Inspector: Exp Date: Instructions: TC STC SH19-4 Issue 1, FAA STC SRD4320N							Handfinish - 4 - 10	
							Handfinish - 4 - 11	
							Handfinish - 4 - 12	
							Handfinish - 4 - 13	
							Handfinish - 4 - 14	
							Handfinish - 4 - 15	
							Handfinish - 4 - 2	
							Handfinish - 4 - 3	
							Handfinish - 4 - 4	
							Handfinish - 4 - 5	
							Handfinish - 4 - 6	
							Handfinish - 4 - 7	
							Handfinish - 4 - 8	
							Handfinish - 4 - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
120	QC 5	1 pcs	7/12/19				QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	

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SEP 11 2019

130 Packaging 1-1 - Pick Kit - B4B 1 pcs	7/12/19	0.00 0.00	QC 5 - 40	
			Packaging 1 - 1 - B4B ✓	
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
135 QC 4	7/12/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
140 Packaging 3-1 - Stock - B4B 1 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	

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				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
155 DC - 1 - B4B	1 pcs	7/12/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
165 QC 21 - SA	1 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - ASSEMBLE AS PER DWG SEE DWG NOTES 9) TORQUE BOLT TO 15 - 25 in-lbs 10) TORQUE NUT TO 44 - 55 in-lbs
Descriptions: In-lbs 11) TORQUE NUT TO 62 - 71 in-lbs 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291 13) FILLET SEAL WITH SIKAFLEX-241/-291 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291 SEALANT ENSURE SADDLE BORE IS FREE OF SEALANT
120 - QC5- Inspect part completeness to step on W/O
130 - Pick Kit - BAG AND ID HARDWARE.
135 - QC4- 100% Inspect kits for completeness
140 - Identify and pack for shipping as per PPP D130-1048-011 Location: _____ PPP Rev: _____
155 - Document Control - Photocopy blue file and create labels as per PPP D130-1048-011 chg 001
165 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
22201BC120090L	Bolt	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	011560
23111AG120LE	Washer	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5197859
AN8C56A	Bolt	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5135792
ASN52320BH120N	Nut	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5197957
D130-1048-041	H130/EC130 - Replacement Skidtube - Standard - LH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5207985
D130-1048-051	H130/EC130 - Wearplates - DART & OEM Replacement - Basic - LH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5203393
D5569-3	Replacement Blade - Basic Aluminum	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	x 5209817
D5570-1	Blade Plug	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5102643
D5594-1	GH Bushing	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5193419
D5594-3	GH Washer	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5196640
NAS1149C0832R	Washer (AN960C816L)	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5076017
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5112909
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5202837
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5196062 ✓
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	(0.2) 5093539 ✓
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging 1-1 - Pick Kit - B4B	5093539 ✓
MS24665-231	Cotter Pin	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5196061 ✓
				113815 ✓

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Handfinish - 4 - Assembly	22201BC120090L	1	0	0
	23111AG120LE	1	40	0
	AN8C56A	3	18	0
	ASN52320BH120N	1	9	0
	D130-1048-041	1	0	0
	D130-1048-051	1	0	0
	D5569-3	1	0	0
	D5570-1	1	4	0
	D5594-1	6	12	0
	D5594-3	6	15	0
	NAS1149C0832R	3	307	0
	NAS1291C8	3	32	0
	23111AG100LE	1	4	0
	ASNA0045BC100L	1	6	0
130-Packaging 1-1 - Pick Kit - B4B	DHS411-101.3106	1	4	0
	MS21141S-06-05	20	90	0
	MS24665-231	1	113	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																											
Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐																											
Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)																											
Description Work Order Deviation		Disposition																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY																													
		<table border="1"><tr><td>Pressure/Forced</td><td>Contamination</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Bending</td><td>Misaligned/off center</td><td>Folio/Program</td><td>Outside Tolerance</td></tr><tr><td>Crushing</td><td>BOM/Route</td><td>Grain Direction</td><td>Drawing</td></tr><tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Finish</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>Incomplete/Unclear Instructions</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Out of Sequence</td><td>Misread</td></tr><tr><td>Mislabeled</td><td>Fit/Function</td><td>Off-set/Set-up</td><td></td></tr></table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function
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Mislabeled	Fit/Function	Off-set/Set-up																													
Other/Details: _____		Completed By _____																													
		Lead hand / Supervisor _____																													
		QC / QA Coordinator _____																													

5.0 PARTS LISTS

5.1 D130-1048-011/-012/-013/-014/-051/-052/-053 Skidtube and Wearplates

QTY -011	QTY -012	QTY -013	QTY -014	QTY -051	QTY -052	QTY -053	P/N	DESCRIPTION
X							D130-1048-011	BASIC SKIDTUBE INSTALLATION, LH
	X						D130-1048-012	BASIC SKIDTUBE INSTALLATION, RH
		X					D130-1048-013	HEAVY DUTY SKIDTUBE INSTALLATION, LH
			X				D130-1048-014	HEAVY DUTY SKIDTUBE INSTALLATION, RH
1		1		X			D130-1048-051 (2)(3)	REPLACEMENT WEARPLATES, LH
	1		1		X		D130-1048-052 (2)(3)	REPLACEMENT WEARPLATES, RH
		1	1			X	D130-1048-053 (3)	MIDTUBE WEARPLATE KIT
1		1					D130-1048-041	SKIDTUBE ASSY, LH
	1		1				D130-1048-042	SKIDTUBE ASSY, RH
				1			D5465-1	FWD WEARPLATE, LH
					1		D5465-2	FWD WEARPLATE, RH
				1	1		D5478-1	AFT WEARPLATE
						1	D5613-041	MIDTUBE WEARPLATE
				8	8		AN3C5A	BOLT
				8	8		NAS1149C0332R	WASHER
						2	D5678-1 (4)	NUT
						2	D4012-1	CUSHION
		1	1				D5569-1 (3)	HEAVY DUTY SKIDTUBE BLADE
1	1						D5569-3 (2)	SKIDTUBE BLADE
1	1	1	1				D5570-1 (2)(3)	BLADE PLUG
1	1	1	1				22201BC120090L (1)(2)(3)	BOLT
1	1	1	1				23111AG120LE (1)(2)(3)	WASHER (or NAS1149C0832R)
1	1	1	1				ASN52320BH120N (1)(2)(3)	NUT
6	6	6	6				D5594-1 (2)(3)	GH BUSHING
6	6	6	6				D5594-3 (2)(3)	GH WASHER
3	3	3	3				AN8C56A (2)(3)	BOLT
3	3	3	3				NAS1149C0832R (2)(3)	WASHER
3	3	3	3				NAS1291C8 (2)(3)	NUT
1	1	1	1				DHS411-101.3106 (1)	BOLT
1	1	1	1				23111AG100LE (1)	WASHER (or NAS1149C0732R)
1	1	1	1				ASNA0045BC100L (1)	NUT, CASTELLATED
1	1	1	1				EN2367-18028 (1)	COTTER PIN (or MS24665-231)
20	20	20	20				MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (or CR7621S06-05)

- (1) Airbus Helicopter Part Numbers (or alternative) included in kit
(2) Pre-assembled on D130-1048-011/-012 Skidtube
(3) Pre-assembled on D130-1048-013/-014 Skidtube
(4) Pre-assembled on D5613-041 Midtube Wearplate